



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

4.5NR-38B
Job Sheet 183089



Part No: 4.5NR-38B

Job Qty: 10 ea

Part Name: Angle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 4.5NR-38 REV.2 IPP REV:A 18.09.NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/19/18	0.00	0.00	Start Up Waterjet		OK 18/10/18
100	Waterjet	10 pcs		9/19/18	0.25	1.00	Waterjet1		OK 18/10/18
110	QC	10 pcs		9/19/18	0.00	0.00	QC2 Waterjet-4		OK 18/10/18
120	QC	10 pcs		9/19/18	0.00	0.00	QC8		38
130	Brake NC	10 pcs		9/19/18	0.25	3.33	Brake NC 1		SB 9-89 DAS
140	QC	10 pcs		9/19/18	0.00	0.00	QC5		38
150	Packaging	10 pcs		9/19/18	0.00	0.00	Packaging3 Large Fab		DAG EL 3-89
160	QC21-SA	10 Ea		9/19/18	0.00	0.00	QC21		21 OCT 16 2018

Part Op 100 - 1-Cut -38B_-38C as per Dwg Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary
Descriptions: 130 - Form as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018S.250	M1018S.250	1.8750 sf (.1875 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018S.250	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

DART
AEROSPACE

1270 Aberdeen Street,
Hamletbury, ON K6A 1K7
CANADA
TEL: 1 513 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S117759

Part: 4.5NR-38B

Job No: 183089

Serial No/Batch: S117759

Revision: 2

Inspector:

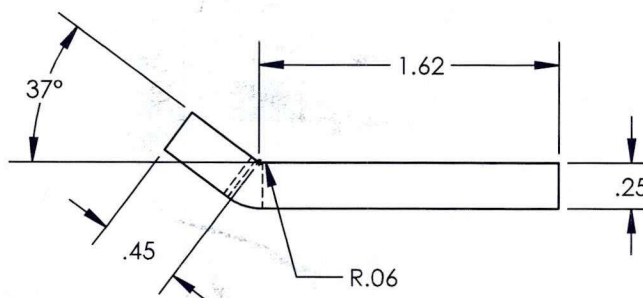
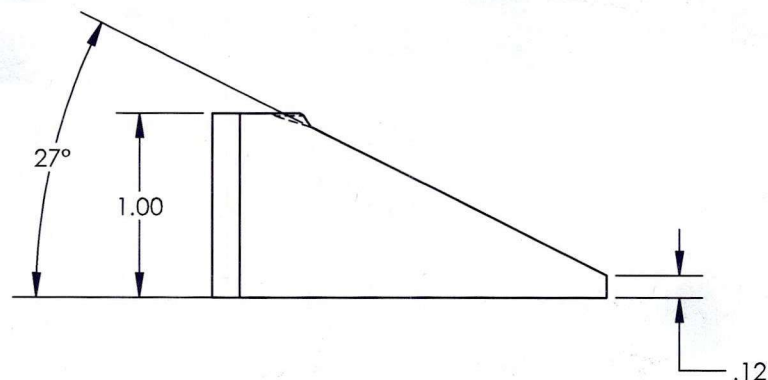
Exp Date:

Instructions:

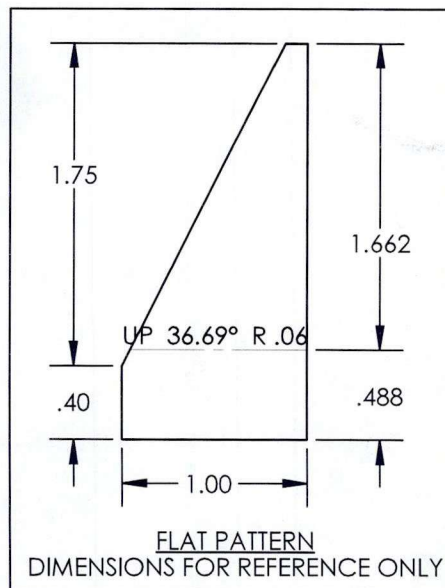
Date: 10/12/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	15-0019	4.5NR-38B CH'D MATL WAS 303 IS 1006-1026.	1/22/2015	DPD	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 183083 MWS
18-09-72



4.5NR-38B

ANGLE

DART AEROSPACE	
TITLE FUNNEL SUB-ASSEMBLY	
DWG NO. 4.5NR-38B	REV 2
MAT'L 1006-1026	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT
.XX ± .03 ANGLES ± .5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:1	DATE 12/23/1997
SHEET 3 OF 6	